

Date: Wednesday, 9/20/2006 3:23:42 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 206/OH-58 SADDLE INBOARD, LEFT SIDE		
Job Number	: 28669					
Estimate Number	: 10833					
P.O. Number	: <i>N/A</i>			Part Number	: D29331	
This Issue	: 9/20/2006 S.O. No. : <i>N/A</i>			Drawing Number	: D2933 REV B	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: <i>N/A</i>			Drawing Revision	: B	
Previous Run	: 28262			Material	: <i>N/A</i>	
Written By	: <i>John 09/20</i>			Due Date	: 9/27/2006	
Checked & Approved By	: <i>John 09/20</i>			Qty:	6 Um: Each	
Comment	: Est: B00-06-26 New DWG rev (mpp 2069) EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6101001	7075-T7351 2X6X6.25
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) Issue material from stock: 7075-T7351 QQ-A-250/12 Cut Size 2.0 x 6.25 X 6.00 Grain Along Long 6.00 Length Batch No: <i>12534</i>
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		Comment: HAAS CNC VERTICAL MACHINING #1 Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 5-Deburr
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
		Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet
4.0	QC1	INSPECT ALL DIM TO DIM SHEET
		Comment: INSPECT ALL DIM TO DIM SHEET

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/06/02
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 9/20/2006 3:23:43 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, LEFT SIDE

Job Number: 28669

Part Number: D29331

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8

SECOND CHECK



Comment: SECOND CHECK

ml 06/09/26

6

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

a.m

06-09-28

6

7.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

am 06/09/28 x 6

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FC 06/09/28 6

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

10/09/28 6

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

10/09/28 6

Job Completion



10/09/28 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	28669
Description: 206 Saddle, Inboard, Left side				Part Number:	D2933-1
Inspection Dwg: D2933 Rev. B				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.123	.123	.124	.124		
B	0.100	0.140		.123	.124	.124	.125		
C	0.100	0.140		.132	.123	.129	.129		
D	0.210	0.230		.221	.221	.221	.220		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.514	.514	.514	.514		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.498	2.498	2.498	2.498		
K	0.257	0.262	DT8683	.258	.258	.258	.258		
L	0.312	0.317	DT8686	.314	.317	.314	.314		
M	0.235	0.240		.237	.238	.237	.237		
N	0.100	0.140		.120	.120	.120	.120		
O	0.540	0.560		.547	.548	.548	.549		
P	0.490	0.510		.500	.498	.497	.498		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.492	2.492	2.492	2.492		
S	0.240	0.270		.230	.250	.248	.249		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321	DT8690	.319	.319	.311	.311		
X	1.125	1.145		1.134	1.135	1.134	1.135		
Y	1.565	1.585	DT8695 A/B	—	—	—	—		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	SA	Audited by:	9nL
Date:	06-09-24	Date:	06/09/24

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	#

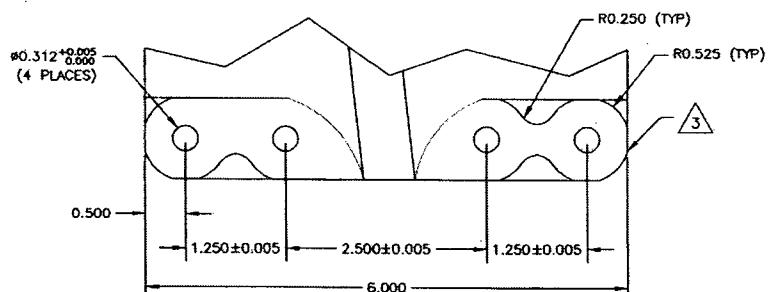
DART AEROSPACE LTD			Work Order:	28669
Description: 206 Saddle, Inboard, Left side			Part Number:	D2933-1
Inspection Dwg: D2933 Rev. B			Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. B and record below:

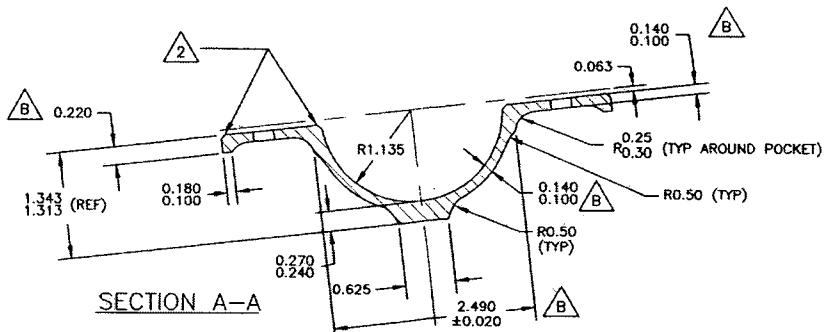
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.124	.124				
B	0.100	0.140		.123	.123				
C	0.100	0.140		.129	.129				
D	0.210	0.230		.220	.221				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.500				
H	0.510	0.515		.514	.514				
I	1.572	1.582		1.577	1.577				
J	2.495	2.505		2.498	2.498				
K	0.257	0.262	DT8683	.258	.258				
L	0.312	0.317	DT8686	.314	.314				
M	0.235	0.240		.237	.237				
N	0.100	0.140		.120	.120				
O	0.540	0.560		.549	.548				
P	0.490	0.510		.500	.499				
Q	3.715	3.725		3.720	3.720				
R	2.470	2.510		2.472	2.472				
S	0.240	0.270		.250	.250				
T	0.100	0.180		.140	.140				
U	1.625	1.635		1.630	1.630				
V	1.362	1.372		1.367	1.367				
W	0.316	0.321	DT8690	.319	.319				
X	1.125	1.145		1.134	1.134				
Y	1.565	1.585	DT8695 A/B						
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	SA	Audited by:	2mk
Date:	06.09.25	Date:	06/09/26

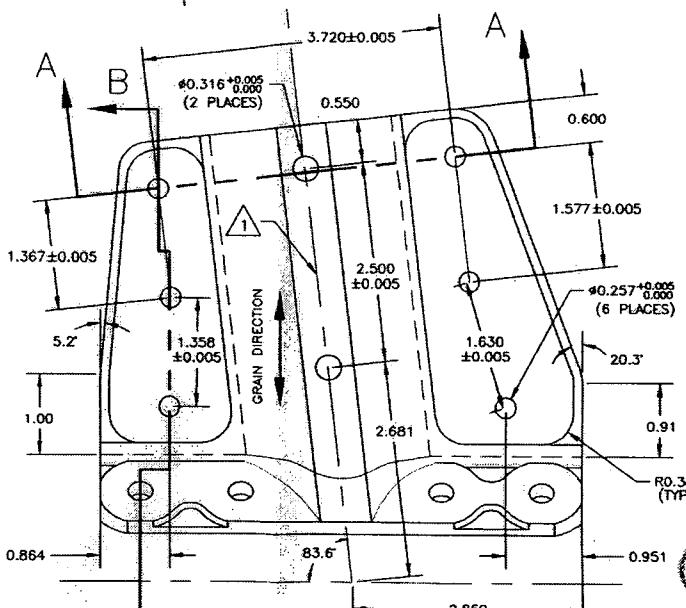
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	#



VIEW C-C



SECTION A-A



D2933-1 LH SADDLE (SHOWN)
D2933-2 RH SADDLE (OPPOSITE)

MATERIAL: 7075-T7351 (QQ-A-250/12)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

6. 亂世裡的黃金：1949-1952年中國經濟的危機與轉折

ENGRAVE PART AND BATCH NUMBER IN THIS

 AREA 0.010 TO 0.015 DEEP

6. **CHANGES IN GENDER AND AGE AT THE TIME OF THE SURVEY**

2 CHAMFER 0.050°
(TYP 2 PLACES)

CHAMEER 0.050" x 45"

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WITHOUT NOTICE
WORK ORDER
28669

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THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE USA, INC.

B	00.05.29	CHANGED GEOMETRY AND MATERIAL		
A	99.10.29	NEW ISSUE		
DESIGN <i>John</i>	DRAWN BY <i>RF</i>	DART DART AEROSPACE USA, INC. BELLEVUE, WA		
CHECKED <i>John</i>	APPROVED <i>John</i>	DRAWING NO. D2933	REV. B	SHEET 1 OF 1
DATE 00.05.29	TITLE SADDLE INSIDE		SCALE 2:3	